

Spies Hecker® VOC Compliance Chart



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Description	Compliant Rule(s)	Applied VOC g/L	Remarks			
Surface Preparation VOC Limit = .42 lbs/gal (50 g/L)						
Permahyd® Silicone Remover 7096		25	Ready to Use			
220™ Axalta Silicone Remover Low VOC		20	Ready to Use			
130™ Axalta Cleaner		0	Ready to Use			
Permahyd® Plastic Cleaning Paste 7081		13	Ready to Use			
265™ Axalta Plastic Cleaning Paste		24	Ready to Use			
Aerosol Cleaners VOC Limit = N/A						
205A Silicone Remover Spray	Aerosol cleaners (non-refillable) *	759 *	Non-refillable aerosol *			
Surface Preparation Limit = N/A - Only if used for spot cleaning in a hand held spray bottle prior to sanding						
Permanent® Silicone Remover 7010 Slow	Used as a spot cleaner only in a hand-held spray bottle prior to sanding	750**				
200 Silicone Remover Slow	Used as a spot cleaner only in a hand-held spray bottle prior to sanding	779**				
225 Bug & Tar Remover	Used as a spot cleaner only in a hand-held spray bottle prior to sanding	347**				
275 Plastic Cleaning Solvent	Used as a spot cleaner only in a hand-held spray bottle prior to sanding	863**				
Description	Mix Ratio	Hardener	Reducer/ Additive	Addtl Product	Max Applied VOC (LE) g/L	Remarks
Pretreatment VOC Limit = 5.5 lbs/gal (660 g/L)						
Primat® Primer 3255 (Aerosol)	Ready to Use	N/A	N/A	N/A	N/A *	Non-refillable aerosol *
Primat® 5.5 Wash Primer 4055	2:1	4056	N/A	N/A	660	
Primat® 1K Primer Surfacer 4085 (Aerosol)	Ready to Use	N/A	N/A	N/A	N/A *	Non-refillable aerosol *
Axalta® Pretreatment Wipes PS4000™	Ready to Use	N/A	N/A	N/A	660	
Primer Surfacer VOC Limit = 2.1 lbs/gal (250 g/L)						
Permacron® VHS Surfacer 5150	1.5:1+0-5%	3192, 3194, 3196	3392, 3394	N/A	250	
Permasolid® 2.1 Surfacer 5157	5:1+10-20%	3192, 3194, 3196	3392, 3394, 5409, 5410	N/A	250	
Permasolid® 2.1 Surfacer 5157 Elasticized	4:1+10-20%	3192, 3194, 3196	3392, 3394, 5409, 5410	+15% 9050	250	9050 must be added before hardener.
Permasolid® 1K UV Starlight Primer Surfacer 9002	Ready to Use	N/A	N/A	N/A	250	
Permasolid® 1K UV Starlight Primer Surfacer 9002 (Aerosol)	Ready to Use	N/A	N/A	N/A	N/A *	Non-refillable aerosol *
Primer-Sealers VOC Limit = 2.8 lbs/gal (340 g/L)						
Permasolid® EP Primer Surfacer 4502	2:1+0-10%	4503	3394	N/A	340	
Permasolid® Spectro Sealer 5450	4:1+30%	3192, 3194, 3196	5409, 5410	N/A	340	
Permasolid® Spectro Sealer 5450 Elasticized	3:1+30%	3192, 3194, 3196	5409, 5410	+15-30% 9050	340	9050 must be added before hardener.
Permahyd® 2K Sealer 5650	1:5%	3080	N/A	N/A	340	
Colour Coating VOC Limit = 3.5 lbs/gal (420 g/L)						
Permahyd® Hi-TEC 480 Base Coat	+10-30%	N/A	6050, 6052, 6053	N/A	420	
Permahyd® Hi-TEC 480 Base Coat w/ Hardeners	+5-10% +10-30%	3080	6050, 6052, 6053	N/A	420	
Permasolid® 2K Midcoat, MC 0001, MC 0002, MC 0003	2:1+10-15%	3192, 3194, 3196	3392, 3394	N/A	420	
Description	Mix Ratio	Hardener	Reducer/ Additive	Addtl Product	Max Applied VOC (LE) g/L	Remarks
Clear Coating VOC Limit = 2.1 lbs/gal (250 g/L)						
Permasolid® Air Dry Clear Coat 8094	4:1 +20%	3192, 3194, 3196	3392, 3392, 3394	N/A	250	
Permasolid® Air Dry Clear Coat 8094 Elasticized	4:1 +20%	3192, 3194, 3196	3392, 3392, 3394	+10% 9050	250	9050 must be added before hardener.
Permasolid® Low VOC Clear Coat 8096	2:1+10-15%	3192, 3194, 3196	3392, 3392, 3394	N/A	250	
Permasolid® Low VOC Clear Coat 8096 Elasticized	2:1+10-15%	3192, 3194, 3196	3392, 3392, 3394	+15% 9050	250	9050 must be added before hardener.
Permasolid® Low VOC Clear Coat 8098 w/ 8092 Matte Clear Coat Additive	See TDS 8092	3192, 3194, 3196	3392, 3392, 3394	N/A	250	
Permasolid® Low VOC Clear Coat 8098 w/ 9055	See TDS 8098	3192, 3194, 3196	3392, 3392, 3394	N/A	250	
Permasolid® Low VOC Clear Coat 8098 Elasticized	2:1+10%	3192, 3194, 3196	3392, 3392, 3394	+15% 9050	250	9050 must be added before hardener.
Permasolid® Low VOC Clear Coat 8098	2:1+5%	3192, 3194, 3196	3392, 3392, 3394	N/A	250	
Uniform Finish Coating VOC Limit = 4.5 lbs/gal (540 g/L)						
Permacron® Speed Blender 1036 w/8096	See 1036 TDS for compliant mixing recommendations				540	
Permacron® Speed Blender 1036 w/8098	See 1036 TDS for compliant mixing recommendations				540	
790 Clearcoat Blender	Aerosol (non-refillable)				See remarks *	Non-refillable aerosol *
Permahyd® Hi-TEC Blend-in Additive 1050 or 1051	+10%	N/A	6050, 6052	N/A	540	
Permahyd® Hi-TEC Blend-in Additive 1050	+5%	N/A	1053	N/A	540	
Adhesion Promoter VOC Limit = 7.0 lbs/gal (840 g/L)						
Primat® Elastic Primer 3304 (Aerosol)	Aerosol	N/A	N/A	N/A	N/A *	Non-refillable aerosol *
Any Other Coating Type VOC Limit = 2.1 lbs/gal (250 g/L)						
Raderal® Spray Polyester 3508	+5%	9520	+5% 7690	N/A	250	
Other Products						
Other components that may be used (list is not all-inclusive). Consult technical data sheet for usage and compliance.						
Permasolid® Clear Coat Color Additive 9056			See 998 TDS for compliant mixing recommendations		420	
Permasolid® Clear Coat Color Additive 9057			See 998 TDS for compliant mixing recommendations		420	
Permasolid® Clear Coat Color Additive 9049			See 998 TDS for compliant mixing recommendations		420	
Permasolid® Clear Coat Color Additive 9045			See 997.0 TDS for compliant mixing recommendations		420	
Axalta E-Coat Restore Aerosols	Aerosol (non-refillable)				N/A *	Non-refillable aerosol *

* Non-refillable aerosols are excluded from Automotive Refinish Regulations

** Excluded product from the Automotive Refinish Regulations

For complete product usage and mixing recommendations, see the product specific technical data sheet

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